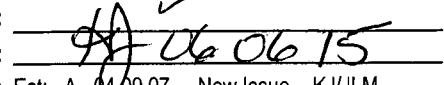
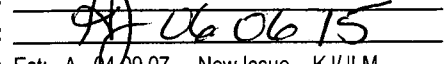


Date: Thursday, 6/15/2006 1:42:28 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	BRACKET ASSEMBLY
<b>Job Number</b> :	27569		
<b>Estimate Number</b> :	10420		
<b>P.O. Number</b> :	N/A	<b>Part Number</b> :	D3303043
<b>This Issue</b> :	6/15/2006	<b>Drawing Number</b> :	D3303 REV. A
<b>S.O. No.</b> :	N/A	<b>Project Number</b> :	N/A
<b>Prsht Rev.</b> :	NC	<b>Drawing Revision</b> :	A
<b>First Issue</b> :	N/A	<b>Material</b> :	N/A
<b>Type</b> :	SMALL / MED FAB	<b>Due Date</b> :	7/30/2006
<b>Previous Run</b> :	26690	<b>Qty:</b>	2 Um: Each
<b>Written By</b> :			
<b>Checked &amp; Approved By</b> :			
<b>Comment</b> :	Est: A 04.09.07 New Issue KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D33031	Plate
-----	--------	-------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

PLATE

Pick:

Qty	Part Number	Description	Batch
1	D3303-1	Plate	B 27649

FF 06-11-23

2

2.0	D33033	Bracket
-----	--------	---------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

BRACKET

Pick:

Qty	Part Number	Description	Batch
1	D3303-3	Bracket	B 29200

FF 06-11-23

2

3.0	MS20426AD33	Rivet
-----	-------------	-------



**Comment:** Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

RIVET

Pick:

Qty	Part Number	Description	Batch
8	MS20426AD3-3	Rivet	M 19099

FF 06-11-23

2

4.0	MS20470AD44	Rivet, Universal Head
-----	-------------	-----------------------



**Comment:** Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Rivet, Universal Head

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes (No) DQA: JD Date: 06/12/05

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Thursday, 6/15/2006 1:42:28 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 27569

Part Number: D3303043

Job Number:



Seq. #:

Machine Or Operation:

Description :

16 MS20470AD4-4 Rivet

M102328

FF 06-11-23

2

5.0

MS21075L3

Nutplate



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

Nutplate

Pick:

Qty Part Number

Description

Batch

4 MS21075L3

Nut Plate

M10534

FF 06-11-23

2

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg D3303

2- Identify as D3303-043

FF 06-11-23

2

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

MA 06/11/23 (2)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

\*\*\*\*MASK THREADS PRIOR TO PAINT\*\*\*\*

am JL 06/12/02 x2

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06/12/05 (2)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

5420

06/12/05 (2)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/12/05 (2)

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

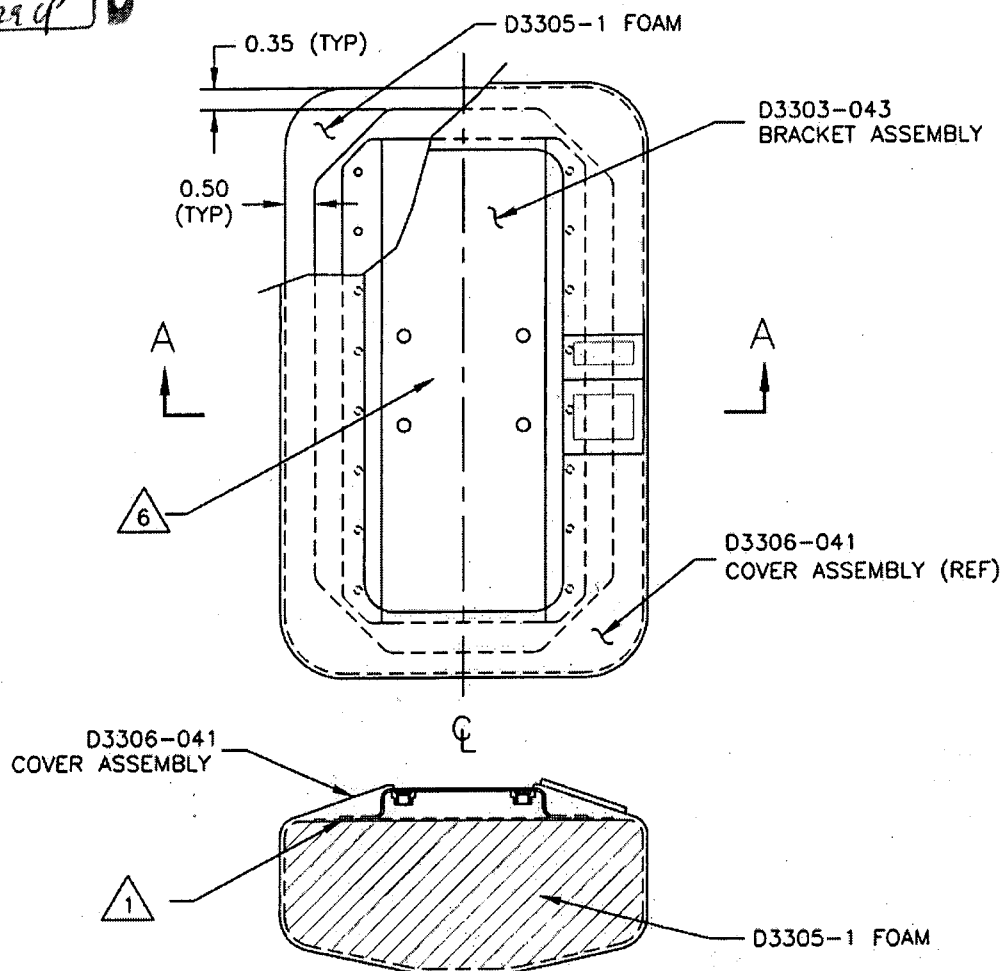
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**DART**

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3303	REV. A SHEET 1 OF 4
DATE 04.08.18		TITLE HEAD REST	SCALE 1:3
A	04.08.18	NEW ISSUE	

**RELEASED**  
64.09.29 6'**SECTION A-A****D3303-041 HEAD REST****D3303-041 NOTES:**

- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE (0.002" to 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 2) COVER HEAD REST WITH D3306-041 AS SHOWN
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY AS FOLLOWS USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD, P/N D3303-041 B/N BXXXXX, FOR PRODUCT  
ELIGIBILITY SEE PDA04-11"

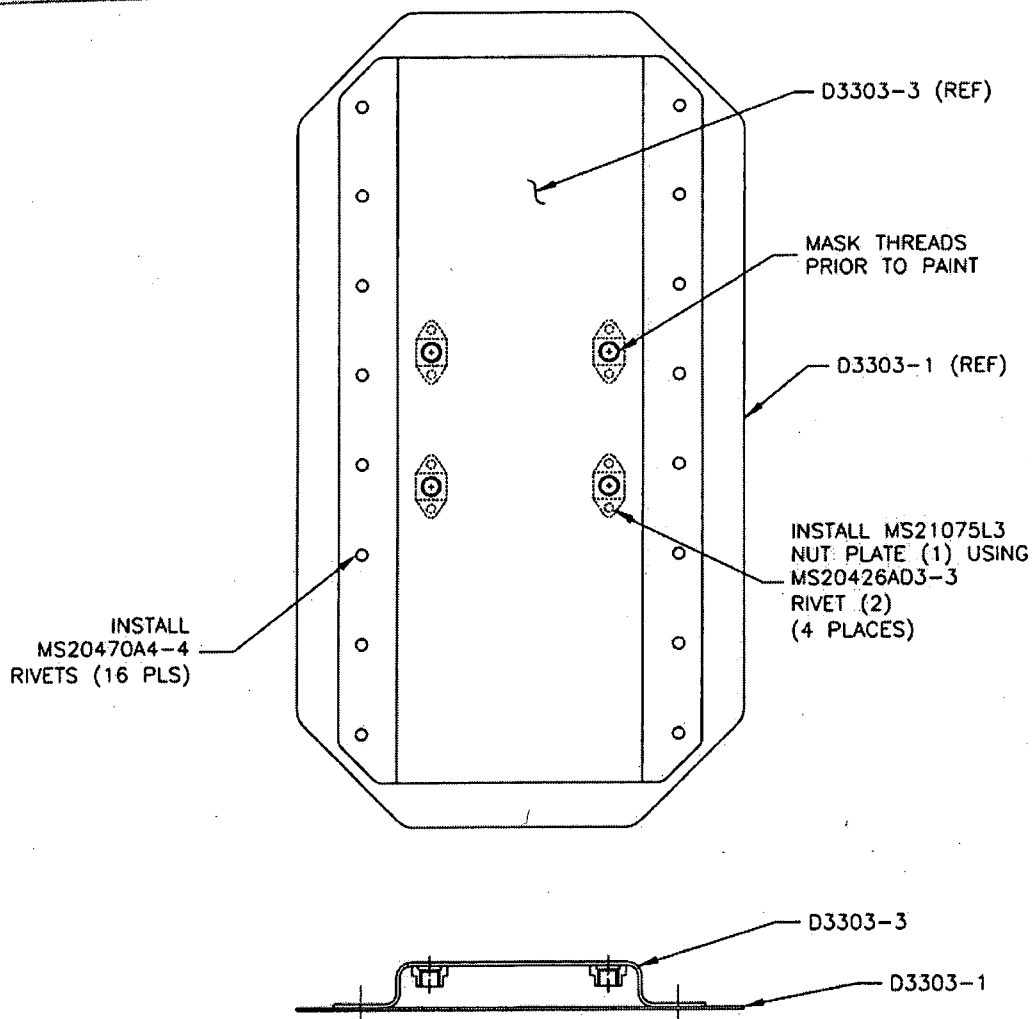
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DATE 04.08.18		TITLE HEAD REST	SCALE 1:1

**RELEASED**  
04.09.29 AP**D3303-043 BRACKET ASSEMBLY****D3303-043 NOTES:**

- 1) FINISH: POWDER COAT ASSEMBLY GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3 WITHOUT NOTICE
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

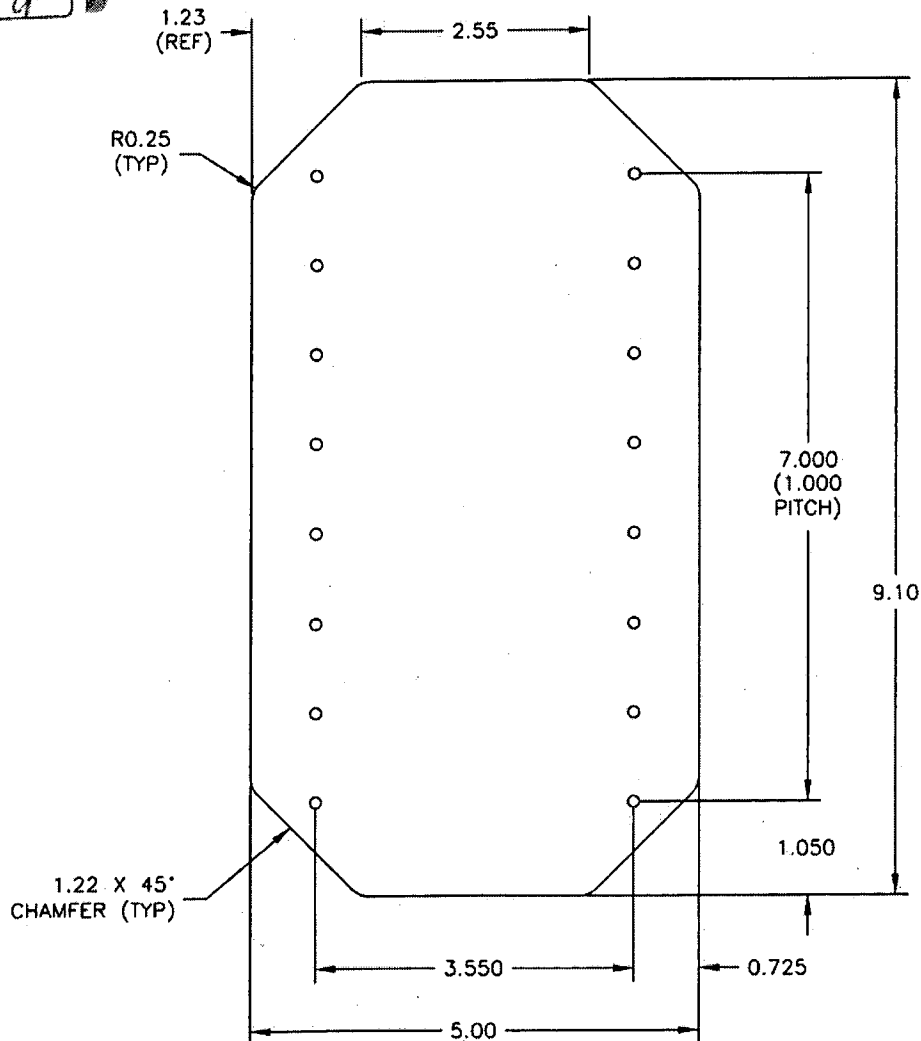
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DATE 04.08.18		TITLE HEAD REST	SCALE 1:2

**RELEASED**  
04.09.29 GP**D3303-1 PLATE****D3303-1 NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK SHEET (REF. DART SPEC M2024T32S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

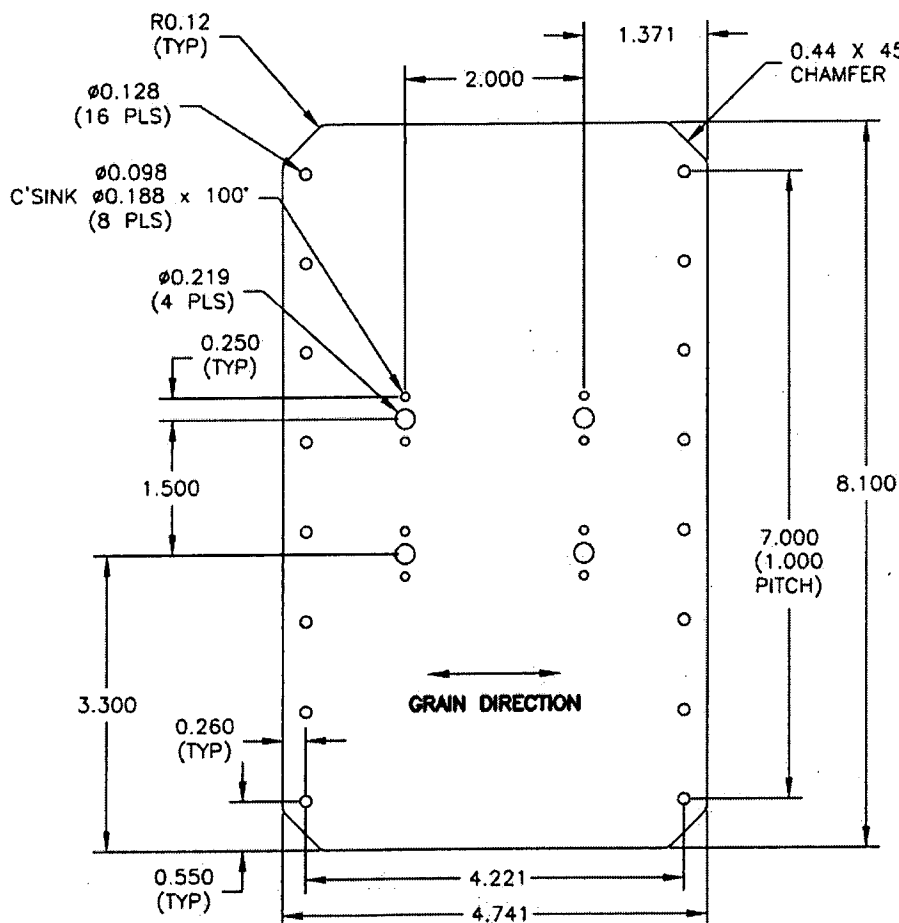
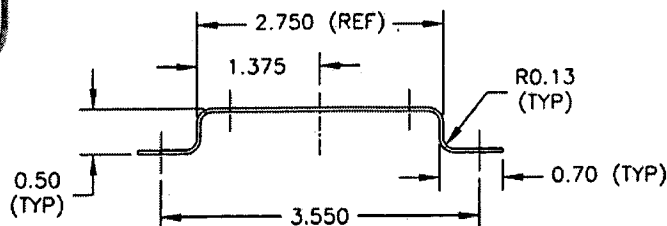
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DATE 04.08.18		TITLE HEAD REST	SCALE 1:2

**D3303-3 FLAT PATTERN****RELEASED**  
04.09.29 CP**D3303-3 BRACKET  
BEND DETAIL****D3303-3 NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK SHEET (REF. DART SPEC M2024T325040)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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